



Dart Hawkesbury
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D3914-041
Job Sheet 167235



Part No: D3914-041

Job Qty: 1 ea

Part Name: Long Basket Lid Assembly (350)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/27/17

Job Tracking No:

Due Date: 11/30/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		11/29/17	0.00	0.00	Start Up Large Fab2		
100	Large Fab	1 pcs		11/29/17	0.00	6.67	Large Fab 1		
110	QC	1 pcs		11/29/17	0.00	0.00	QC9		PD 17-11-21
120	QC	1 pcs		11/29/17	0.00	0.00	QC5		PD 17-11-21
130	Powdercoat	1 pcs		11/29/17	0.00	0.40	Powdercoat4		BR 17-11-22
135	QC	1 pcs		11/29/17	0.00	0.00	QC3		11/17/11/27
140	HandFinish	1 pcs		11/30/17	0.00	0.80	HandFinish3		11/17/11/27
150	QC	1 pcs		11/30/17	0.00	0.00	QC3		33
160	Packaging	1 pcs		11/30/17	0.00	0.00	Packaging3		11/12/11/30
170	QC21-SA	1 Ea		11/30/17	0.00	0.00	QC21		21

Part Op 100 - 1- assemble ribs , weld as per dwg D3914 using DT9607A 2- weld hinge (3) and Mounting brackets as per dwg D3914
Descriptions: D3914 ***Visual inspect before welding mesh*** 3- tack weld mesh on basket as per dwg D3914 ***Cut out mesh where label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label plate before tacking mesh***
130 - *** mask sides of hinge prior to powdercoat***
140 - 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install label as per dwg ***Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***

M 135418 START: 11:35 O.V.T. 300° FINISH: 12:05.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	5005812 D2581-1	2	18	0	0
	5004269 D3914-1	2	6	0	0
	F160518 D3914-7	2	10	0	0
	F160518 D4016-3	3	19	0	0
	5001023 D4018-5	9	45	0	0
	5001023 D4020-5	1	8	0	0
	5001023 D4021-3	1	7	0	0
	5001023 D4035-043	2	0	0	0
140-HandFinish	5004890 D2728-3	1	0	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		

Date : _____ Step #: _____

Description Work Order De

DART
AEROSPACE
S011498

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IRB (QSI042) Approval

Completed By

Lead hand / Supervisor
Approval VerificationQC / QA Coordinator
Approval

PART NO:
Revision:
Operation:
Change No:

D3914-041**Start up Operation****Mfg Date: 11/20/17****Job No: 167235**
 Positioned Wrong
 Outside Dimensions
 Over/Under tolerance
 Part Incorrect
 Part Lost/Missing
 Part Moved
 Drawing
 Finish
 Misread
 Turning Sequence

Root Cause	
Environment ☐	No Re-verification ☐
Design ☐	Operator ☐
Doc/Data ☐	Offset/Setup ☐
Equip/Tooling ☐	Supplier ☐
Handling/Pre ☐	Training ☐
Material ☐	Use for Testing ☐
Internal Transport ☐	Poor Information ☐
Tribal Knowledge ☐	Rushing ☐
LOA ☐	Product Improvement ☐
Substation ☐	Process Improvement ☐
Past Expiry Date ☐	Manufacturing Process ☐
Misidentified ☐	Past Due ☐

Press ☐Bend ☐Centr ☐Crack. ☐Crimp/Kink/Ripple/Wave ☐Cuffs ☐Crushing ☐Heat Treat ☐Wave/Twist in Tube ☐Marks/Chatter ☐OTHER : ☐Inspection Incomplete/Unqualified ☐Contamination ☐Countersink ☐Cut Too Short ☐Instructions Incomplete/Unclear ☐Drill Holes ☐Wrong Stock Pulled ☐Out of Sequence ☐Off-set ☐Mislabeled ☐Fit/Function ☐Misaligned/off center ☐